



Dart Aerospace Ltd.
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D119-696-013
Job Sheet 175965



002748

Part No: D119-696-013

Job Qty: 4 ea

Part Name: Dual Mirror Installation



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 4/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG IIN-D119-696 REV A SHEETS 5,6,7, DSI9578 REV A IPP Rev:A 08-02-19 New issue DD verified by: LL
IPP REV:B 11.01.19 AS PER CHG005 DD VERF:EC IPP REV:C 11.11.14 AS PER CHG006 DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	4/27/18	4/27/18	0.00	0.00	Start Up Stores/Pkg-1		APR 24 2018
110	Packaging	4 pcs	4/27/18	4/27/18	0.00	0.00	Packaging1-1		58 DAS
120	QC	4 pcs	4/27/18	4/27/18	0.00	0.00	QC4		58 DAS
125	DC	4 pcs	4/27/18	4/27/18	0.00	0.00	DC		9-89 58 DAS
130	Packaging	4 pcs	4/27/18	4/27/18	0.00	0.00	Packaging3-1		21 DAS
140	QC21-FG	4 Ea	4/27/18	4/27/18	0.00	0.00	QC21		9-89 21 DAS

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

125 - Document Control Photocopy bluefile & type labels per PPP D119-696-013 CHG006

130 - Identify as per dwg & Stock Location: Identify and pack for shipping as per PPP D119-696-013 LOCATION: FG016

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
ALS4-1032-130	Rivnut	8 Ea (2 ea)	90-Start up Operation	F1136549-4 Fm13624
AN526-1032R9	Screw	16 Ea (4 ea)	90-Start up Operation	F1137736-4
D119-696-043	Dual Cargo Mirror Assembly, 6 Inch Round	4 Ea (1 ea)	90-Start up Operation	5062624
D2053	Bracket	4 Ea (1 ea)	90-Start up Operation	F108846x2 5027177x2
D2067	Connector	4 Ea (1 ea)	90-Start up Operation	F105444
D2071	Cable Assembly - 32"	4 Ea (1 ea)	90-Start up Operation	F152586
D3083-1	Placard	4 (1 ea)	90-Start up Operation	5062869
MS21919-DG5	Clamp	8 Ea (2 ea)	90-Start up Operation	504954x2 5044536x6
MS27039-1-09	Screw	16 Ea (4 ea)	90-Start up Operation	5017101
MS35489-9	Grommet	4 Ea (1 ea)	90-Start up Operation	F1136044
NAS1149D0363J	Washer	16 Ea (4 ea)	90-Start up Operation	5015269

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	ALS4-1032-130	8	14,777	0
	AN526-1032R9	16	92	0
	D119-696-043	4	0	0
	D2053	4	12	0
	D2067	4	5	0

2000
03
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03

Date: 04/24/10

Inspector:

Revision: A/A

Serial No/Batch: S064469

Job No: 175965

Part: D119-696-013



Container No: S064469

DART
AEROSPACE

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D2071	4	5	0
D3083-1	4	0	0
MS21919-DG5	8	30	0
MS27039-1-09	16	216	0
MS35489-9	4	40	0
NAS1149D0363J	16	2,782	0

Part Specifications

Specifications could not be found.

Plex 4/12/18 3:18 PM Dart.lajeunesse.marie

25.2 CARGO MIRROR REMOVAL

1. Loosen MS21042-3 nut and remove D2071 control cable from D2067 connector.
2. Remove (4) MS27039-1-09 screws and remove D3072-1/-2 brackets. Re-install MS27039-1-08 screws.
3. Remove (2) AN526-1032R9 screws and (2) MS21919DG5 clamps.
4. Remove (2) AN526-1032R9 screws, the D2053 bracket and the D2071 cable assembly. Re-install AN526-1032R9 screws to plug inserts.
5. Seal MS35489-9 grommet hole with PRC / RTV / Proseal 890 / Sikaflex-241 / Sikaflex-291 / MIL-C-8802 Class B2 sealant.

25.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-696-011 Cargo Mirror Installation	2.2 lb 1.00 kg	7.0 in 0.28 m	15.4 in-lb 0.28 m-kg	22.0 in 0.87 m	48.4 in-lb 0.87 m-kg
D119-696-013 Cargo Mirror Installation	3.0 lb 1.36 kg	1.0 in 0.04 m	3.0 in-lb 0.05 m-kg	22.0 in 0.87 m	66.0 in-lb 1.18 m-kg

25.4 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Part Number	Description
X				D119-696-011	SINGLE CARGO MIRROR INSTALLATION
	X			D119-696-013	DUAL CARGO MIRROR INSTALLATION
1		X		D119-696-041	SINGLE CARGO MIRROR ASSEMBLY
	1		X	D119-696-043	DUAL CARGO MIRROR ASSEMBLY
		1	2	D2011-101	MIRROR ASSEMBLY
1	1			D2053	BRACKET
		2	2	D2054	BUSHING
		2	2	D2055	CLAMP
		1	1	D2056	BELL CRANK
		1		D2057	PLUG
1	1			D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	2	*D3014-1	LOCKNUT
		1	1	D3072-1	BRACKET
		1	1	D3072-2	BRACKET
		1		D3074-1	ARM
			1	D3074-3	ARM
1	1			D3083-1	PLACARD
4	4			AN526-1032R9	SCREW
4	4	6	6	AN960JD10	WASHER
		1	2	*AN960JD416L	WASHER
		3	3	MS21042L3	NUT (or MS21042-3)
2	2			MS21919DG5	CLAMP
4	4			MS27039-1-09	SCREW
		3	3	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
2	2			AKS7-1032-130	INSERT (or ALS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or AELS-032-130)

*INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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25-00-00

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Description: CARGO MIRROR INSTALLATION

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					